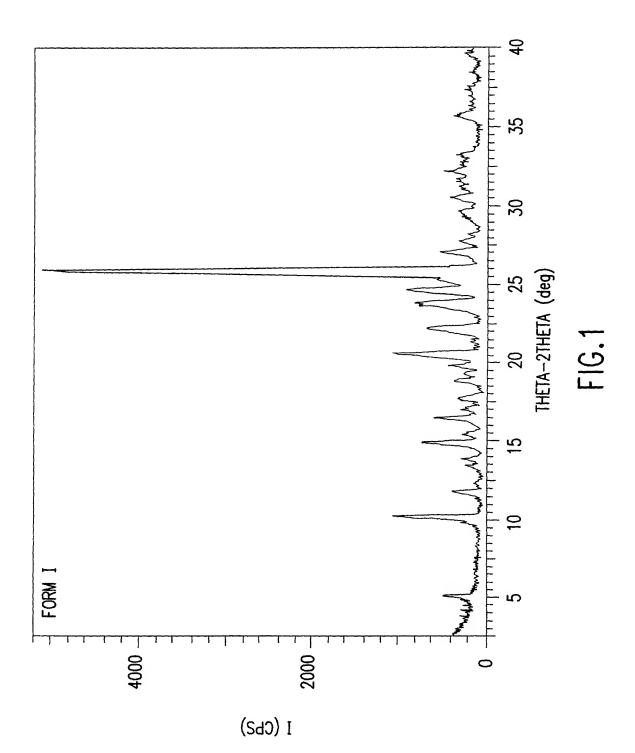
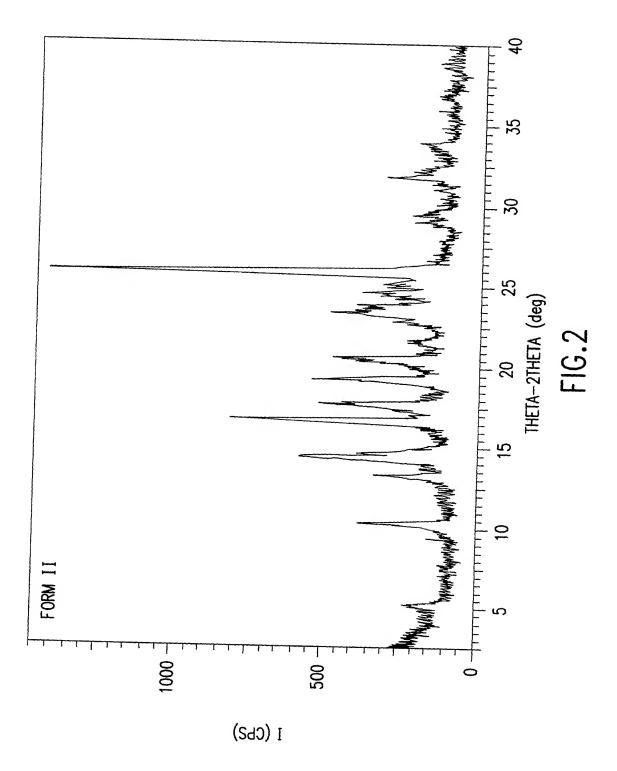
1/12



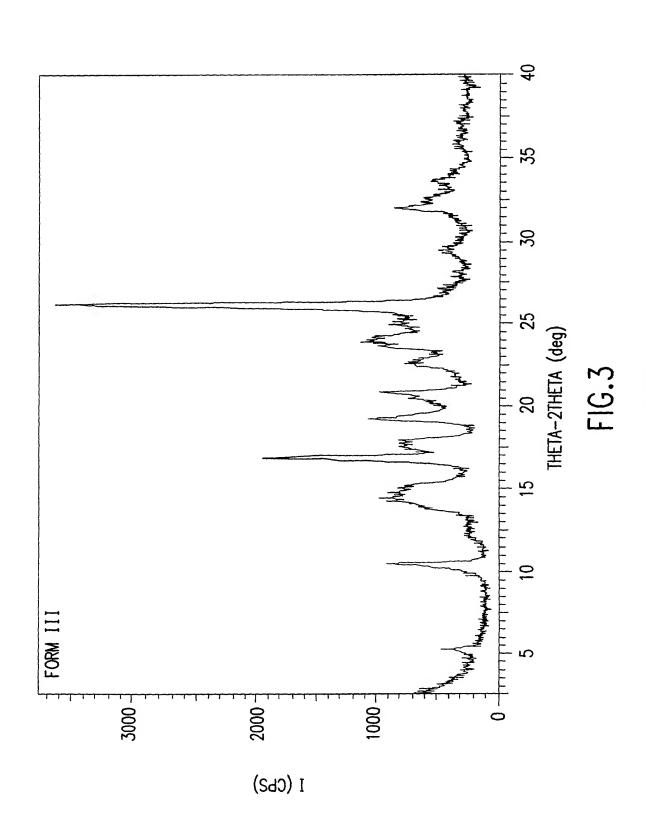
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Application No.: N/A Customer to Inventors: Anthony F. Hadfield, etal
Attorney Docket No.: AM100463
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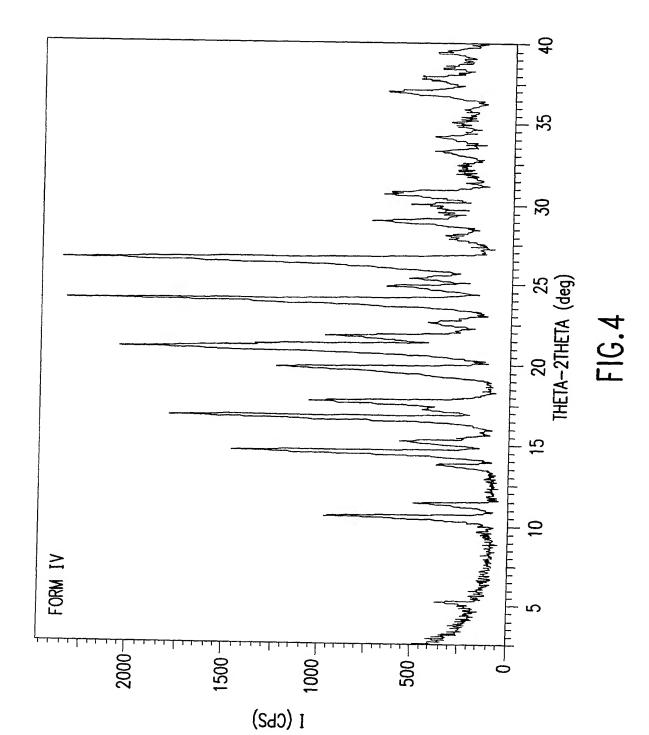




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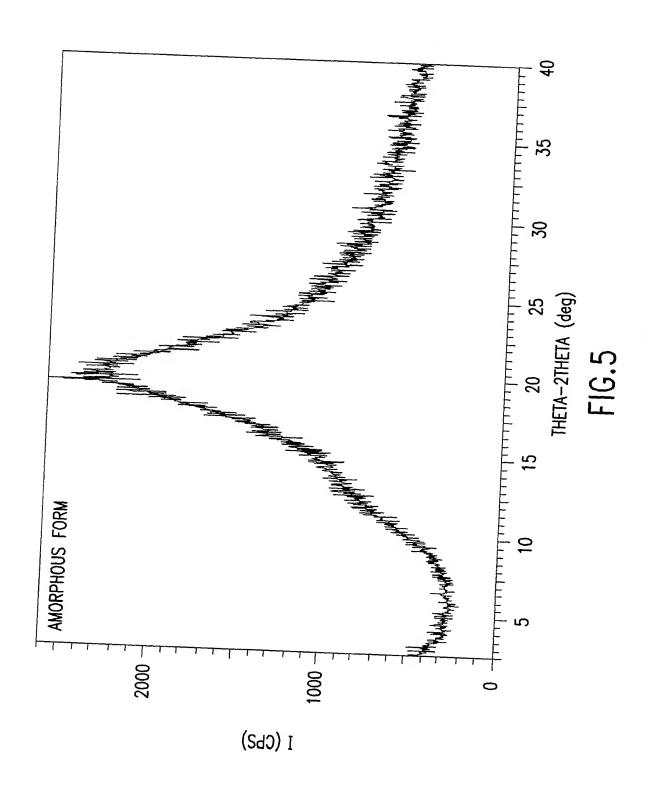
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Title: Novel Succinate Salt of O-Desmethyl-Venlafaxine

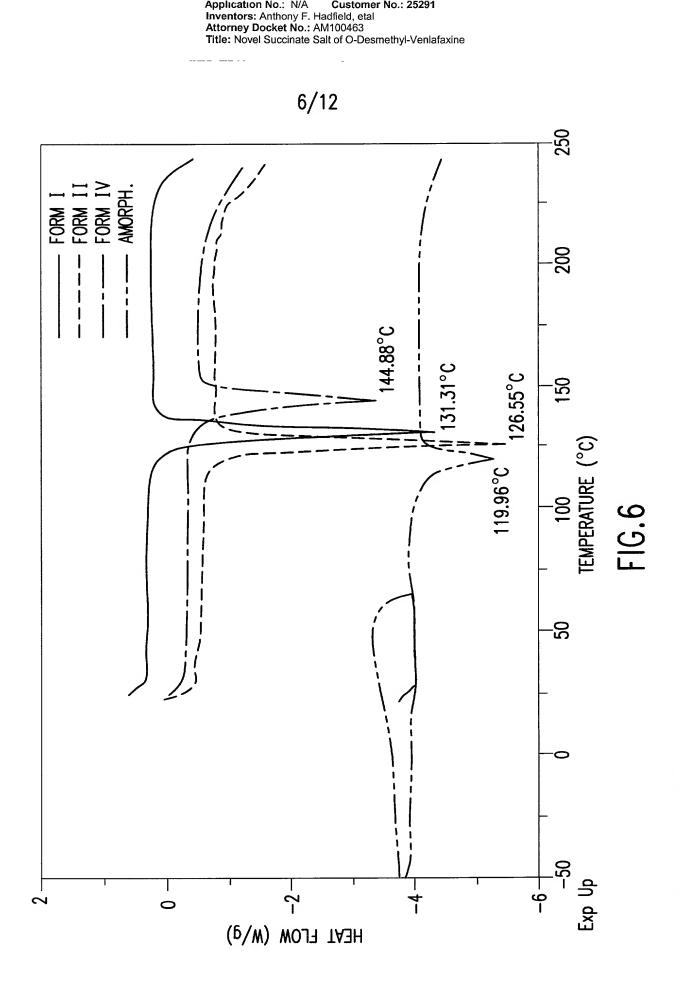
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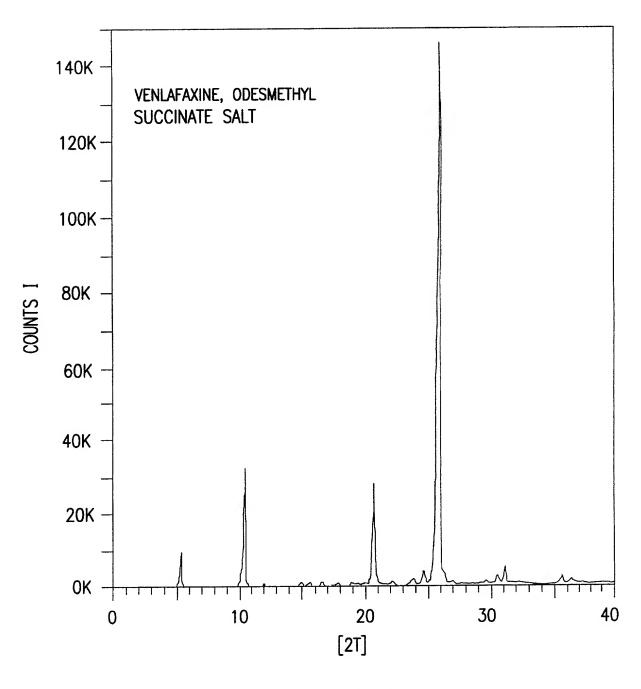
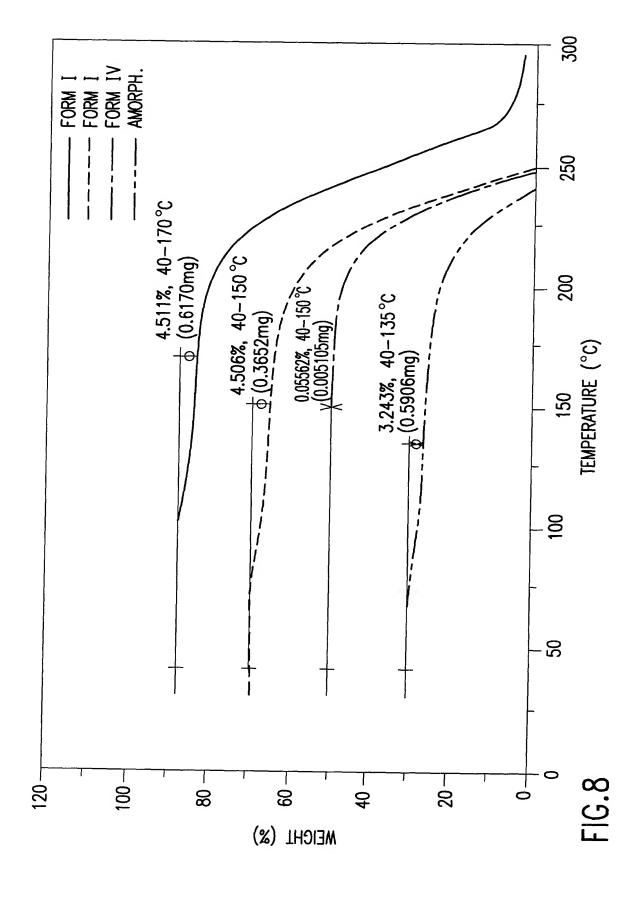


FIG.7

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RAT JEJUNAL ABSORPTION OF ODV SUCCINATE AND INTERNAL MARKERS [ODV SUCCINATE] = 50 ug/ml, PERFUSION BUFFER, pH6.8

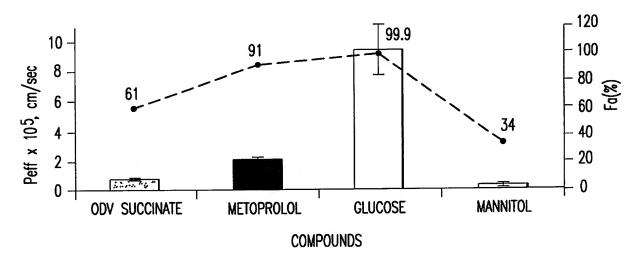


FIG.9

INTESTINAL SITE-SPECIFIC ABSORPTION OF ODV SUCCINATE [ODV SUCCINATE] = 50 ug/ml, PERFUSION BUFFER, pH6.8

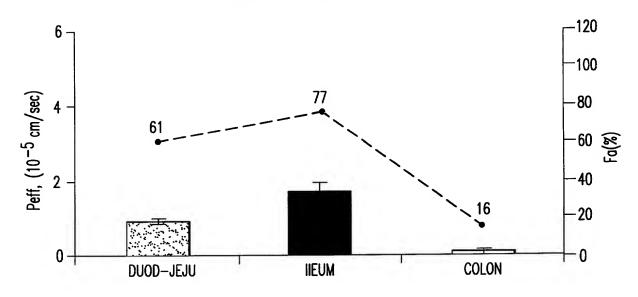


FIG.10

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Inventors: Anthony F. Hadfield, etal

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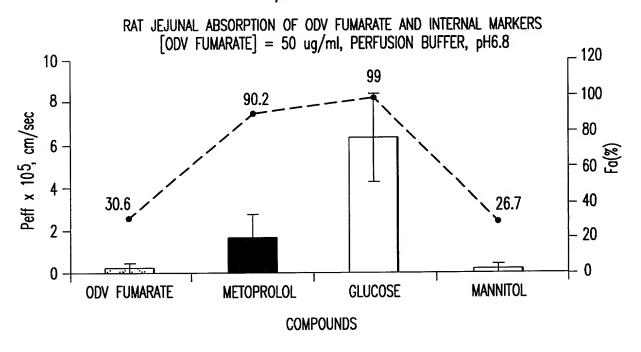


FIG.11

INTESTINAL SITE—SPECIFIC ABSORPTION OF ODV FUMARATE [ODV FUMARATE] = 50 ug/ml, PERFUSION BUFFER, pH6.8

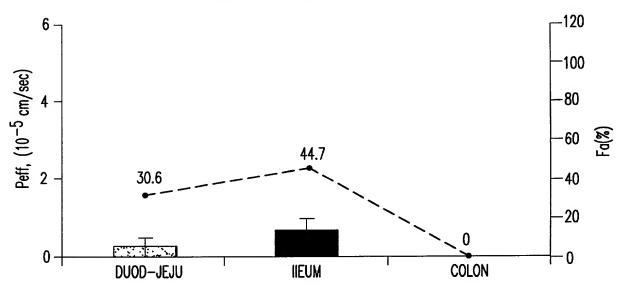
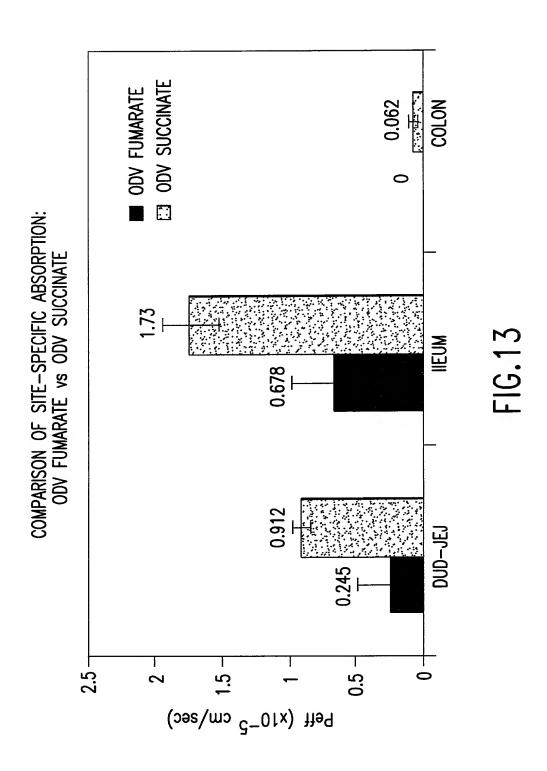


FIG.12

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MW 58.44 MW 18.02

MW 40.00

C₁₂H₂₇B MW 182.16 $+ H_2 + CH_4 + 2(s-Bu)_3B$ + NaCl + H20 MW 42.39 MW 2.02 MW 16.04 + 2LiCl NMe₂ . HCl .NMe2 C₁₆ H₂₆ CINO₂ MW 299.84 C16H25N02 MW 263.381 .NMe2 C₁₆H₂₃NO₂Li₂ MW 275.24 오 . 오 10N NoOH TO pH 9.6 12N HCI TO pH 3.5 FILTER C₁₂H₂₈BLi MW 190.11 MW 36.46 + 3HCI + NaOH NMe2 .HCI .NMe2 .NMe₂ C₁₆H₂₃NO₂Li₂ MW 275.24 C₁₆H₂₆CINO₂ MW 299.84 $C_{17}H_{27}N_{0}_{2}$ MW 277.40 <u>0</u> 오 Meo